

Work Order ID 149800

Wednesday, August 03, 2016 1:26:12 PM

149800

Reprint

Page 1

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 8/30/2016 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 9/12/2016 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 03 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.83
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 3.700" long
 60 0 DAS 44 9-89 16-08-18

110 HAAS CNC VERTICAL MACHINING #1 0.04
110
 HAAS 1 Memo 1.50
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3
 Dwg Rev A Folio Rev A
 60 DAS 44 9-89 16-08-19
 160820

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.10
 Quality Control
 60 DAS 44 9-89 16-08-19
 160820

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Item ID: D2873-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut Plate Assembly

Start Date: 8/30/2016 Start Qty: 60.00

60

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.20

Hand Finishing

(x60)  7-016/09/02
BEB

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.10

Quality Control

60X  16/09/13
DAS 36 9-89

180

Small Fab

0.00

180

Small Fab

Memo

0.30

Small Fab

1-Assemble as per Dwg D2873 2-Identify as D2873-043

60X  16/09/13
DAS 36 9-89

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Required Date: 9/12/2016 Req'd Qty: 60.00 ***60*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
190									
QC	Memo	0.20							
Quality Control									SEP 14 2016
200	Identify as per dwg & Stock Location: _____	0.00							
200									
Packaging	Memo	0.10							
Packaging	LOCATION : LG050								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	1.00							
Quality Control									

DAS
21
9-89

NOV 17 2016

DAS
21
9-89

NOV 17 2016

Picklist Print

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Page 1

Work Order ID: 149800

149800

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 8/30/2016

Required Date: 9/12/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.375X01.00
0

Purchased

No

180

f

30.4630

0.3083

19.47158

M6061T6B0.375X01.000

6061T6 BAR .375 x 1.00

**

DAS
44
9-89

16-08-18

Location

Loc Qty

Loc Code

MAT

30.463

m134984

10.463

*m135377

20

191

MS20426AD4-6

Purchased

No

180

Each

1,841.000

6

360

MS20426AD4-6

Rivet

**

DAS
36
9-89

16/09/13

Location

Loc Qty

Loc Code

GA

236

M128812

16

M133234

220

ST311

1605

M134502

1605

360

MS21075L5

Purchased

No

100

Each

302.0000

3

180

MS21075L5

Nut Plate

**

DAS
36
9-89

16/09/13

Location

Loc Qty

Loc Code

GA

219

m134955

219

LG001

3

m134955

3

ST298

80

m133498

30

m135297

50

99

8

1

M135470 (8/12)

DART AEROSPACE LTD		Work Order:	149800
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

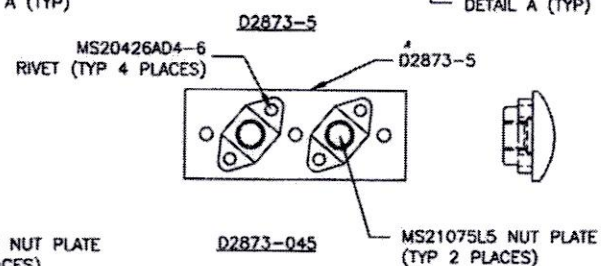
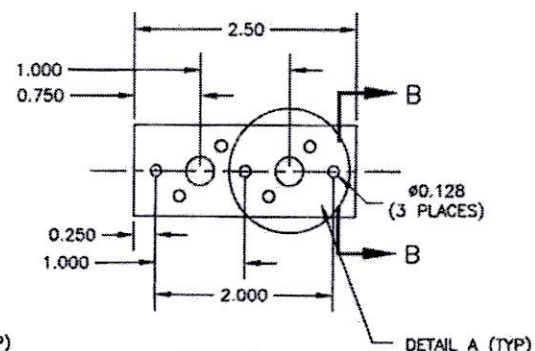
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	/		Vern	FK-04
2.000	+/-0.010	2.000	/			
0.750	+/-0.010	.750	/			
1.000	+/-0.010	1.000	/			
0.250	+/-0.010	.250	/			
1.000	+/-0.010	1.000	/			
2.000	+/-0.010	2.000	/			
3.000	+/-0.010	3.000	/			
Ø0.128	+0.005/-0.001	.129	/			
0.359	+/-0.010	.359	/			
Ø0.316	+0.006/-0.001	.316	/			
1.000	+/-0.010	.997	/			
0.250	+/-0.010	.246	/			
0.061	+/-0.010	.061	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .125	/		↓	↓

Measured by: DAS 457 Date: 16-08-19	Audited by: DAS 14 Date: 14/08/21	Prototype Approval: Date:	N/A N/A
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Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	



D2873-1/-3/-5 RADIUS BLOCK

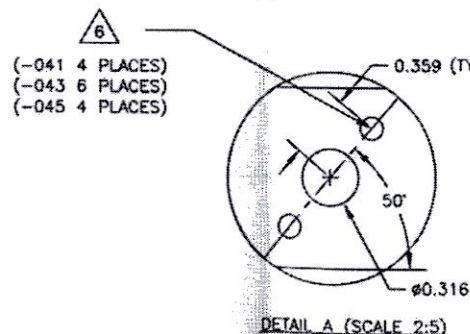
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"
- 

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS210751.5	NUT PLATE



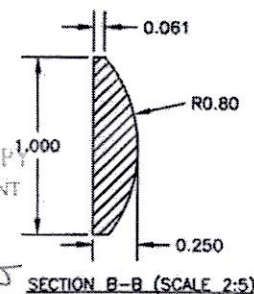
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 149800 MJS

16-08-03



RELEASED
05-07-26

A	05.07.26		NEW ISSUE	
DESIGN	PH	DRAWN BY	 DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
1 DS	1 DS	D2873	SHEET 1 OF 1	
DATE	TITLE		SCALE	
05.07.26	RADIUS BLOCK		4:5	